

Work Order ID 68802

Thursday, April 21, 2011 7:43:01 AM

Page 1

Item ID: D212-664-201TRN

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Turning Detail

Start Date: 4/21/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D212-664-241

Rev D

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114
2-Turn first side as per Folio FA114
3- File transition lines smooth.

cmk 11/05/03

1

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

cmk 11/05/03

1

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA114
2- File transition lines smooth.
3-Remove sand and plugs
4- scribe batch # and part # as per dwg

cmk 11/05/03

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68802

Thursday, April 21, 2011 7:43:01 AM



Page 2

Item ID: D212-664-201TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 4/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC1- Inspect dimensions to dimension sheet Memo	0.00 0.00		ant 11/05/03		1	0		
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SL 11/05/04		①			
150 HandFXtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion Memo Chemical Conversion Coat as per within 24 hours of machining	0.00 0.00		SAD 11-05-05		①			

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 68802

Thursday, April 21, 2011 7:43:01 AM



Page 3

Item ID: D212-664-201TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 4/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

= 7 min 11/05/05



170



Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify and stock in kanban rack

Location: L GUNDRING
Gear

SAD 11/05-05



180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

11/5/05

MF
11-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 7:43:09 AM

Page 1

Work Order ID: 68802



Parent Item: D212-664-201TRN



Parent Item Name: Crosstube Turning Detail

Start Date: 4/21/2011

Required Date: 4/26/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 Removed polish EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6006-129

Manufactured

No

120

Each

33.0000

1

1



Crosstube Material

Location

Loc Qty

Loc Code

LG

33

23970

2

26550

15

→ 29112

7

34690

3

38338

6

04/11/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: C8802
Description: Crosstube Assembly (205/212 High Aft)	Part Number: D212-664-241
Inspection Dwg: D212-664-241 Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.210	—		Vern ML-7	
	R0.063	+/-0.010	R.063	—		R-g	
	2.990	+0.005/-0.000	2.995	✓		micr cnc-04	
	5.237	+/-0.030	5.240	✓		vern ML-7	
	2.600	+0.005/-0.000	2.605	✓		micr cnc-04	
	2.686	+0.005/-0.000	2.691	✓		"	
	2.770	+0.005/-0.000	2.775	✓		"	
	2.854	+0.005/-0.000	2.859	✓		"	
	2.938	+0.005/-0.000	2.942	✓		"	
	3.021	+0.005/-0.000	3.026	—		Micr cnc-05	
	3.133	+0.005/-0.000	3.138	—		"	
	3.179	+0.005/-0.000	3.184	—		"	
SIDE B	0.200	+/-0.010	.210	—		Vern ML-7	
	R0.063	+/-0.010	R.063	—		R-g	
	2.990	+0.005/-0.000	2.993	✓		micr cnc-04	
	5.237	+/-0.030	5.237	✓		vern ML-7	
	2.600	+0.005/-0.000	2.605	✓		micr cnc-04	
	2.686	+0.005/-0.000	2.691	✓		"	
	2.770	+0.005/-0.000	2.775	✓		"	
	2.854	+0.005/-0.000	2.858	✓		"	
	2.938	+0.005/-0.000	2.943	✓		"	
	3.021	+0.005/-0.000	3.026	✓		Micr cnc-05	
	3.133	+0.005/-0.000	3.138	✓		"	
	3.179	+0.005/-0.000	3.184	✓		"	
	124.362	+/-0.020	124.375	✓		tape ML-2	
						T.	

Measured by: <i>Amk</i>	Audited by: <i>Sh</i>	Preliminary Approval:	N/A
Date: 11/05/03	Date: 11/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ <i>Amk</i>	<i>Amk</i>

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	4	4	MS21920-28	CLAMP (OR MS21920-30)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.362±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: D212-664-241 = 44.2 lbs (PER IIN-D212-664)
D212-664-241B = 44.2 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68802
201101-21

DEO ATTACHED

RELEASED
2009-10-29
W

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3; C6-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>PH</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>PH</u>	DRAWING NO.	REV. D
MFG. APPR.	<u>PH</u>	D212-664-241	SHEET 1 OF 4
APPROVED	<u>PH</u>	TITLE	SCALE
DE APPR.	<u>PH</u>	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

12 13 15
D2940-1 SUPPORT
MS21920-28 CLAMP, 2X
D3595-063-530 RUBBER CUSHION, 2X
2 PL

A5-2

A

14.00 (-241)
OR 13.75 (-241B)

D

D212-664-601
BENT TUBE

C
SYM

D212-664-241/-241B
ASSEMBLY DETAIL

D

u to 65862

DEO ATTACHED

RELEASED
2009-10-28

12
APPLY MAGNOBOND
BETWEEN D2940-1 AND
CROSSTUBE

D2940-1 SUPPORT, REF

13 15
MS21920-28
CLAMP, REF

D3595-063-530 RUBBER CUSHION
UNDER CLAMP, REF

SECTION A-A 06-2
SCALE 4X

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	98	DRAWING NO.	REV. D
MFG. APPR.	15	D212-664-241	SHEET 2 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	14	CROSSTUBE ASSY (205/212 HI AFT)	NTS
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8 7 6 5 4 3 2 1

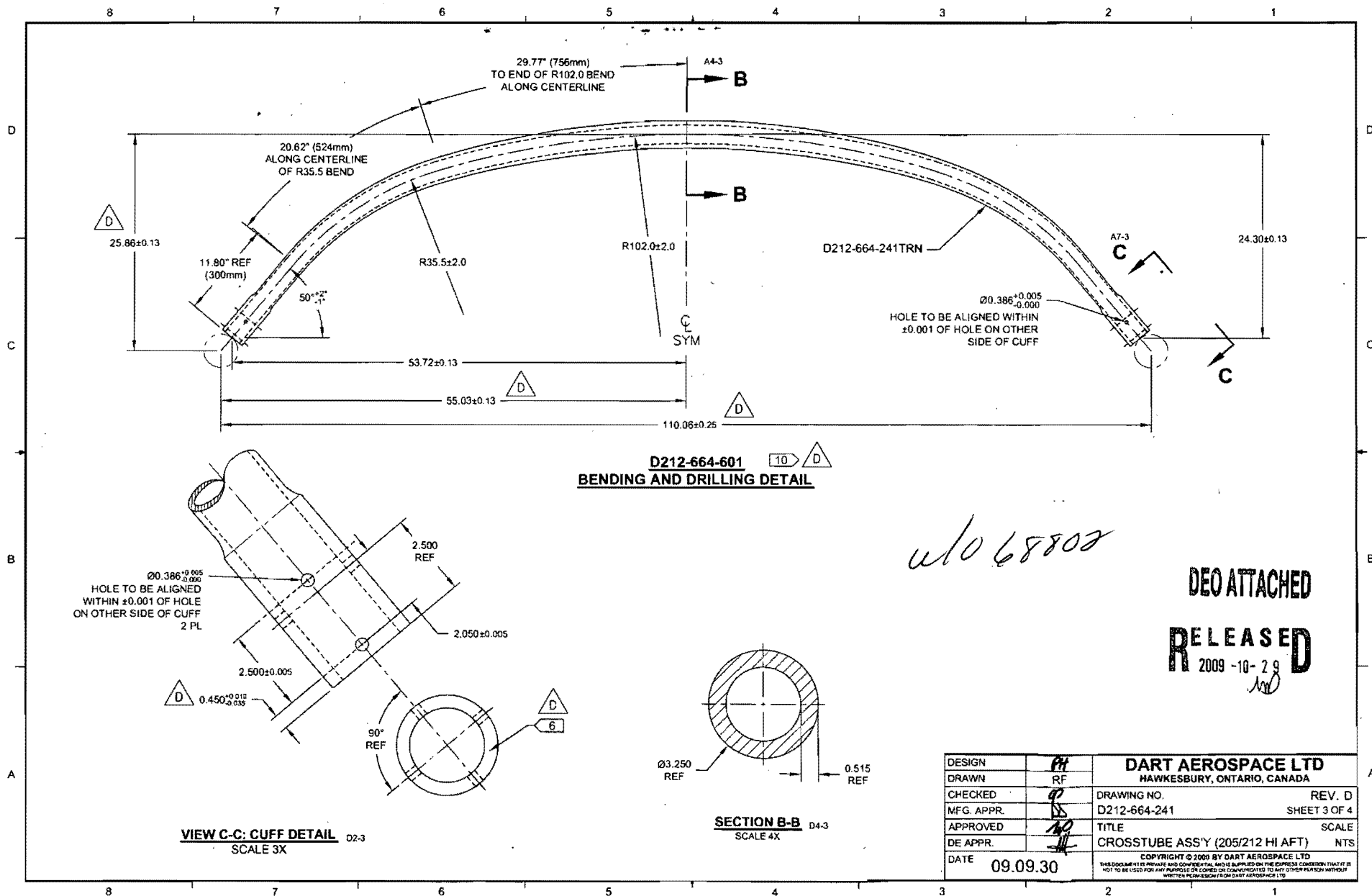
W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

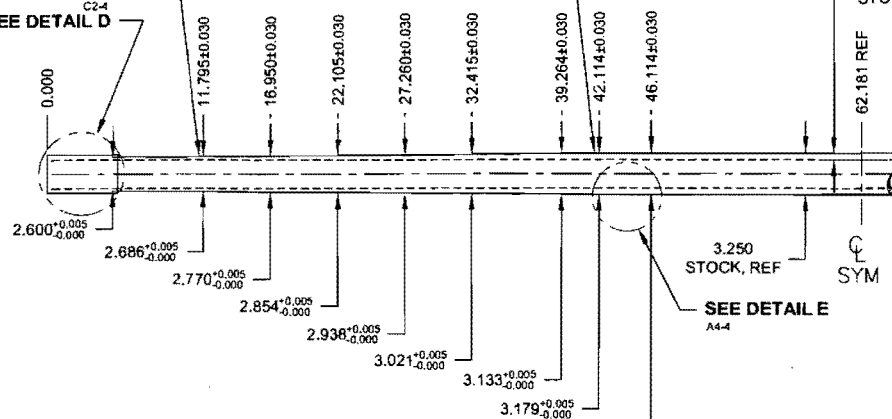
NOTE: Date & initial all entries

R100.0 TRANSITION
BETWEEN TAPERED
SECTIONS

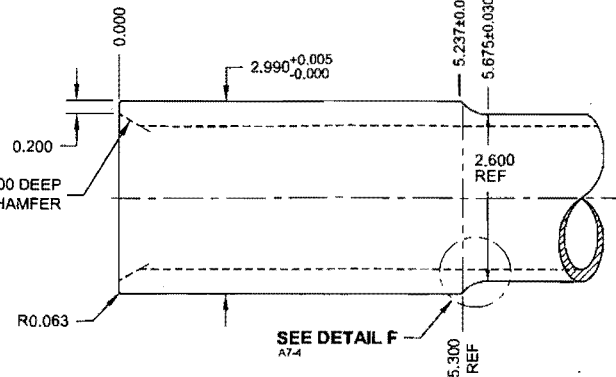
R100.0 TRANSITION
BETWEEN TAPERED
SECTIONS

0.515 WALL
STOCK, REF

SEE DETAIL D



9
30° X 0.500 DEEP
CHAMFER



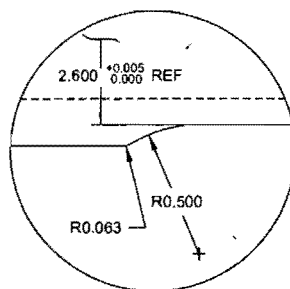
DETAIL D:
CROSSTUBE CUFF D8-4
SCALE 5X

W/0 68802

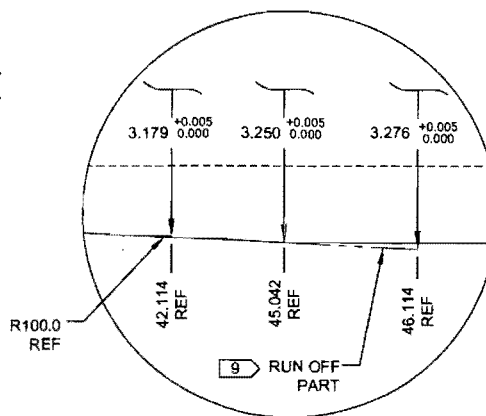
DEO ATTACHED

RELEASED
2009-10-29

D
D212-664-241TRN
TURNING DETAIL



DETAIL F:
CUFF TRANSITION C2-4
SCALE 10X



DETAIL E:
TAPER RUN-OFF C5-4
NOT TO SCALE

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	AS	D212-664-241	SHEET 4 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	CROSSTUBE ASS'Y (205/212 HI AFT)	NT
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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NOTE: Date & initial all entries

DRAWING NO. D212-664-241	TITLE CROSSTUBE ASSY (205/212 HI AFT)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-241-D-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12			

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND
PAINT OUTSIDE PER DART QSI 005 4.2
REMOVE MASKING AND APPLY CLEAR COAT

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

RELEASED
2011-04-18
JH

w/o 68802

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

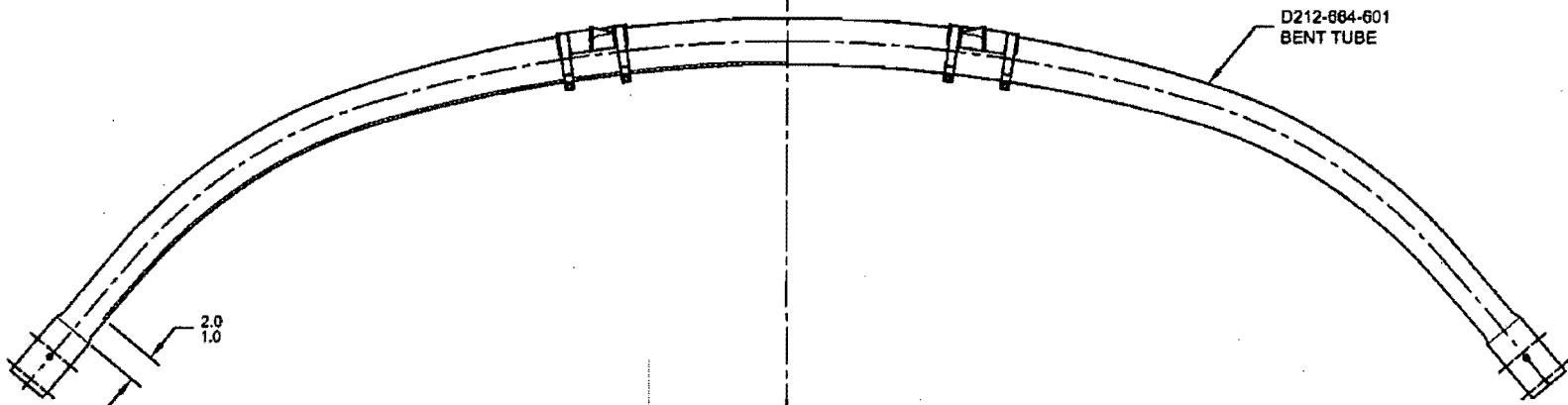
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DRAWING NO. D212-664-241	TITLE CROSSTUBE ASSY (205/212 HI AFT)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-241-D-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED <i>UP</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>	DE APPR. <i>#</i>		
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12		

IS:

WAS:

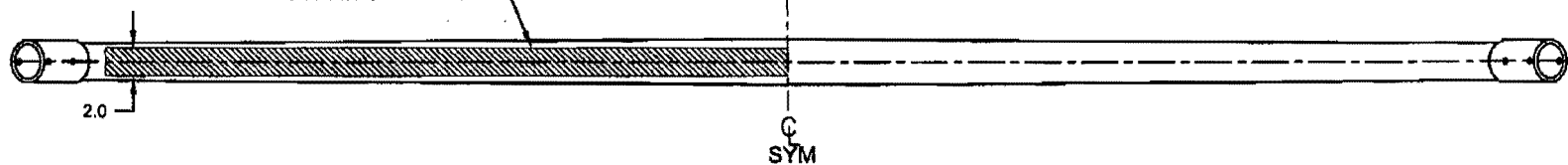


**D212-664-241/-241B
ASSEMBLY DETAIL**

RELEASED
2011-04-18
MD

u 68800

MASK AREA PRIOR TO PAINTING,
REMOVE MASKING AFTER PAINT
AND APPLY CLEAR COAT



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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries